

Work Order ID 99224

99224

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April 3, 2013 1:07:17 PM

Item ID: D6207

Accept

N9000040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Angle Extrusion

Start Date: 4/03/13 Start Qty: 80.00 *80*

Cust Item ID:

Required Date: 4/12/13 Req'd Qty: 80.00 *80*

Customer:

Reference:

Approvals: Process Plan: CL Date: 13/04/03 Tooling: _____ Date: _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop *NR2*

Draw Nbr	Revision Nbr	Operation Description	Set Up Run Hours	1	2	3	4	Plan Code	As Bld	Rele. Qty	Rejc. Num.	asp. Stamp
D6207	Rev A											

100 PURCHASING 0.00

100

Purchasing

Memo

0.00

Purchasing

Issue P/O: 19541 a) Description: Angle extrusion 25 ft long 1.000" x 1.000" x 0.125" b) Material: 6061-T6/T6511 (QQ-A-200/8) c) Minimum ultimate tensile strenght = 38 ksi d) Minimum yield tensile strenght = 35 ksi

CL 13/04/10 80ft

110 Receive & Inspect for Damage & Mat'l Certs 0.00

110

Packaging

Memo

0.00

Packaging

Ensure material certification is attached

80x 13-4-11

120 QC6- Inspect dimensions to drawing 0.00

120

QC

Memo

0.00

Quality Control

Ensure Material certification comply to Dwg D6207 Check hardness with Webster tester

DAS
16
8-33 13/04/12 B.A
13/04/12

80ft

Work Order ID 99224

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Item ID: D6207 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Angle Extrusion
 Start Date: 4/03/13 Start Qty: 80.00 ***80*** Cust Item ID:
 Required Date: 4/12/13 Req'd Qty: 80.00 ***80*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	Identify as per dwg & Stock Location: <u>MAT 07</u>	0.00				80ft	0		D.A. 13/04/12
130									
Packaging	Memo	0.00							
Packaging									
140	QC21- Final Inspection - Work Order Release	0.00							
140									
QC	Memo	0.00							
Quality Control									

13/4/15

13-04-12

Picklist Print

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Work Order ID: 99224

Parent Item: D6207

Parent Item Name: Angle Extrusion

Start Date: 4/03/13

Required Date: 4/12/13

Start Qty: 80.00

Required Qty: 80.00

Comments: IPP A: 02.03.15New Issue NG

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D6207P Angle Extrusion 1x1x.125		Purchased	No			110	f	0.0000	1	80			

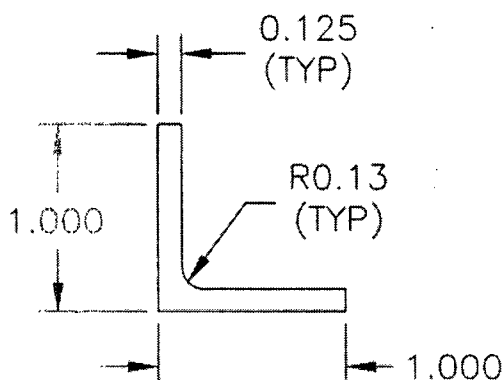
~~80x~~ 80 SPB-4-11



DESIGN #	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. D6207	REV. A SHEET 1 OF 1
DATE 02.03.13		TITLE ANGLE EXTRUSION	SCALE 1:1
A	02.03.13	NEW ISSUE	

RELEASED
02.03.13

SPECIFICATION CONTROL DRAWING



C213/04/03

W10:99224

D6207-XXX ANGLE EXTRUSION
WHERE XXX IS LENGTH IN INCHES


EG.
D6207-027 IS 27 INCHES LONG

PURCHASE MATERIAL: ALUMINUM ANGLE
1.000" x 1.000" x 0.125"
6061-T6/T6511 (QQ-A-200/8)
MINIMUM TENSILE STRENGTH = 38 ksi
MINIMUM YIELD TENSILE STRENGTH = 35 ksi

TOLERANCES ARE PER DART QSI 016 UNLESS OTHERWISE NOTED

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BY 
S / GST REG. N° R 135 534 717 • N° ENR. TVQ / QST REG. N° 1 015 668 543

sapa:

Test de dureté Rockwell Rockwell Hardness Test

Client / Customer :

Adresse / Address :

commande Sapa / Sapa order # : 2110283

bon de commande / Purchase order # : OU-39059

de matrice / Die # : MS 15914

Description : 2"X 1" FLAT BAR

Alliage & trempage / Alloy & temper : 6061 T6 Longueur / Length : 6096 mm

Contrôle / Control # : 81037-1

Coulée / Cast # : 13030071B

Dureté Rockwell E /

Rockwell E hardness : 92 HRE

Min. requis /

Min. required : 88 HRE

Max. permis /

Max. permitted : 100 HRE

Composition chimique typique / Typical chemical composition :

	Si	Fe	Cu	Mn	Mg	Cr	Zn	Ti
6063	0,20 - 0,60	0,35 Max	0,10 Max	0,10 Max	0,45 - 0,90	0,10 Max	0,10 Max	0,10 Max
6005	0,60 - 0,90	0,35 Max	0,10 Max	0,10 Max	0,40 - 0,60	0,10 Max	0,10 Max	0,10 Max
6005A	0,66 - 0,74	0,14 - 0,28	0,08 - 0,16	0,18 - 0,26	0,46 - 0,54	0,03 Max	0,05 Max	0,05 Max
6061	0,40 - 0,80	0,70 Max	0,15 - 0,40	0,15 Max	0,80 - 1,20	0,04 - 0,35	0,25 Max	0,15 Max
6351	0,7 - 1,3	0,5 Max	0,10 Max	0,40 - 0,80	0,40 - 0,80	—	0,20 Max	0,20 Max

Nous certifions que le matériel fourni rencontre les exigences chimiques telles qu'annoncées par la norme ASTM B-221-08 excepté pour la section 8.2 (nombre de spécimen) .

We hereby certify that the material supplied meets the chemical properties as published by the ASTM B-221-08 except for section 8.2 (number of specimen) .

Sincèrement vôtre,
Yours truly,

date : 2013-03-19



Gilles Pelletier
Technicien de la qualité
Quality technician

FILE 12



Test de dureté Rockwell Rockwell Hardness Test

Client / Customer :

Adresse / Address :

commande Sapa / Sapa order # : 2091204

bon de commande / Purchase order # : CA-38517

de matrice / Die # : MS 9605

Description : 1"x1"x 1/8"STRUCT.ANGLE

Alliage & trempage / Alloy & temper : 6061 T6 Longueur / Length : 6096 mm

Contrôle / Control # : 77883-1

Coulée / Cast # : 55025

Dureté Rockwell E /

Rockwell E hardness : 92 HRE

Min. requis /

Min. required : 88 HRE

Max. permis /

Max. permitted : 100 HRE

Composition chimique typique / Typical chemical composition :

	Si	Fe	Cu	Mn	Mg	Cr	Zn	Ti
6063	0.20 - 0.60	0.35 Max	0.10 Max	0.10 Max	0.45 - 0.90	0.10 Max	0.10 Max	0.10 Max
6005	0.60 - 0.90	0.35 Max	0.10 Max	0.10 Max	0.40 - 0.60	0.10 Max	0.10 Max	0.10 Max
6005A	0.66 - 0.74	0.14 - 0.28	0.08 - 0.16	0.18 - 0.26	0.46 - 0.54	0.03 Max	0.05 Max	0.05 Max
6061	0.40 - 0.80	0.70 Max	0.15 - 0.40	0.15 Max	0.80 - 1.20	0.04 - 0.35	0.25 Max	0.15 Max
6351	0.7 - 1.3	0.5 Max	0.10 Max	0.40 - 0.80	0.40 - 0.80	---	0.20 Max	0.20 Max

Nous certifions que le matériel fourni rencontre les exigences chimiques telles qu'annoncées par la norme ASTM B-221-08 excepté pour la section 8.2 (nombre de spécimen) .

We hereby certify that the material supplied meets the chemical properties as published by the ASTM B-221-08 except for section 8.2 (number of specimen) .

Sincèrement vôtre / Yours truly, date : 2012-10-11

OK 13/4/12

Gilles Pelletier
Technicien de la qualité
Quality technician



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID PO19541

Purchase Order Date 4/10/13

PO Print Date 4/10/13

Page Number 1 of 1

Order From :

VC-CAM002

CAMPI STEEL
935 BOUL. DU HAVRE
VALLEYFIELD, QC J6S 5L1
CA

Contact Name

Vendor Phone 800 667 4248

Vendor Fax 450 377 5696

Vendor Account Nbr

Buyer

Chantal Lavoie

Requisition Nbr

Tax Resale Nbr

10127-2607

Terms

Net 30

Currency

CAD

FOB

Destination-Collect

Ship To :

DART AEROSPACE LTD

1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

FXED
4/30/13

Line Nbr	Reference Revision ID Vendor Part Number	Description/ Mfg ID	Req Date/ Taxable	Req Qty/ Unit of Measure	Ship Method	Unit Price	Extended Price
1	M6061T6B1.000X02.000	6061-T6 Bar 1.00 x 2.00	7/11/13 Yes	100.00 f	Yours ppd	\$5.8988	\$589.88

Special Inst:

MATERIAL: 6061-T6/T651/T6510/6511/T62 ALUMINUM BAR
AS PER QQ-A-225/8 OR AMS-QQ-A-225/8
OR AMS 4117/4128/4115/4116
OR QQ-A-200/8 OR AMS-QQ-A-200/8 OR
AMS 4160 OR ASTM B211 OR
ASTM B221

2

D6207P

Angle Extrusion 1.00 x 1.00

7/11/13

Yes

80.00

f

Yours ppd

\$0.6662

\$53.30

Special Inst:

AS PER DWG D6207 REV. A
B99224
MATERIAL 6061-T6/T6511 AS PER QQ-A-200/8

PO Total:

\$643.18

CERTIFICATION
REQUIRED UPON DELIVERY

Change Nbr:

1

Change Date: 4/10/13

No substitution or deviation without
consent.
Certificate of Conformity or Material
Certification required **YES** NO